

# Work Order ID 55334

January 13, 2010 10:25:34 AM



Page 1

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RF*

Date: *10-1-13*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

*FB 10-1-18*

FLOW CNC Waterjet

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev: *D* L.Prog  
Rev: *D* 12-Deburr if necessary

*304 . 663*



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

*FB 10-1-18*

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

*2) 8106119*



Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Debur if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155. Form Joggle as per Dwg D3564 on brake using Jig DT 8157

SB 10/01/19

12

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

=> 5 10/01/19

(412)

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch I/A/R 2059B Hardcoat  
11/13/21 Weld hardcoat as per Dwg D3564

EL

10-1-21

(418)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Item ID: D3564-9

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Item Name: Wearshoe

Start Date: 1/13/10

Start Qty: 10.00



Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

=> Scola/22

(X12)

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

=> Scola/22

(X12)

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

11112588  
N => 10/02/10

(X12)

Powder Coating

START TIME: 2:30pm FINISH TIME: 3:09pm OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January 13, 2010 10:25:34 AM



Page 4

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Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

*BL 10-02-10-*

*(12)*



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location:

*FPK*

0.00

*W 10/02/10*

*(V12)*

*Q*



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/02/11*

*MF 10-2-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

January 13, 2010 10:25:38 AM

Page 1

Work Order ID: 55334



Parent Item: D3564-9



Parent Item Name: Wearshoe

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP Rev:A New Issue 07-03-08 ec  
IPP Rev:B As per Rev C 07-07-09 JLM  
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S16GA		Purchased	No			100	sf	318.2779	11.5789	14		



304/316 Sheet .063

10-1-18

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

318.2778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

255.1895

12

13095

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	55334
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3564-9
<b>Inspection Dwg:</b> D3564 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.222	*			
2.432	+/-0.010	2.436	*			
2.50	+/-0.030	2.50	*			
6.000	+/-0.010	6.000	*			
12.104	+/-0.010	12.104	*			
18.000	+/-0.010	18.000	*			
18.000	+/-0.010	18.000	*			
18.00	+/-0.030	18.00	*			
9.00	+/-0.030	9.00	*			
11.50	+/-0.030	11.50	*			
0.300 x 0.300	+/-0.010	303 X 303	*			
Ø0.188	+0.005/-0.001	.190	*			
R0.375	+/-0.010	.375	*			
0.063	+/-0.010	.060	*			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-1-18	<b>Date:</b> 10/01/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

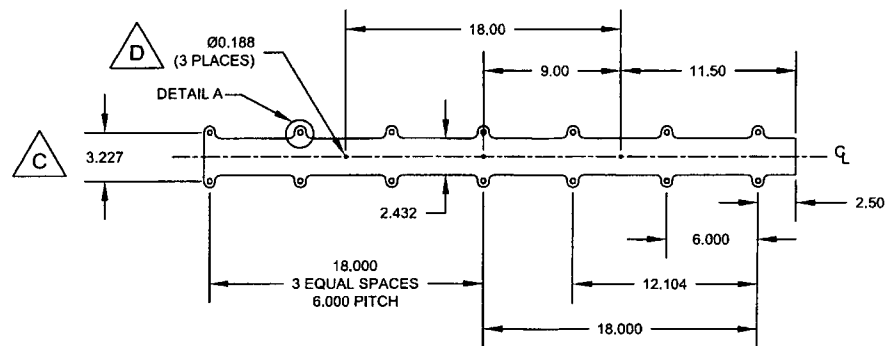
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

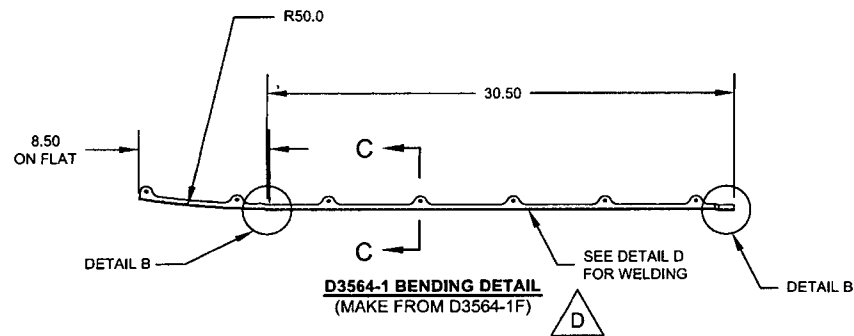
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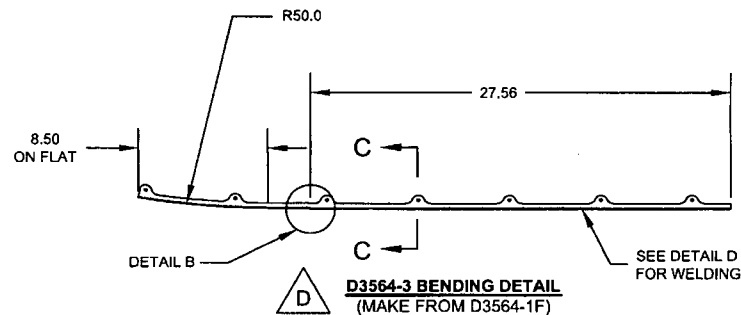
**NOTE:** Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)**

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55334  
10-1-13

RELEASED  
07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564  
REV. D  
SHEET 1 OF 3  
TITLE WEARSHOE  
SCALE 1:8

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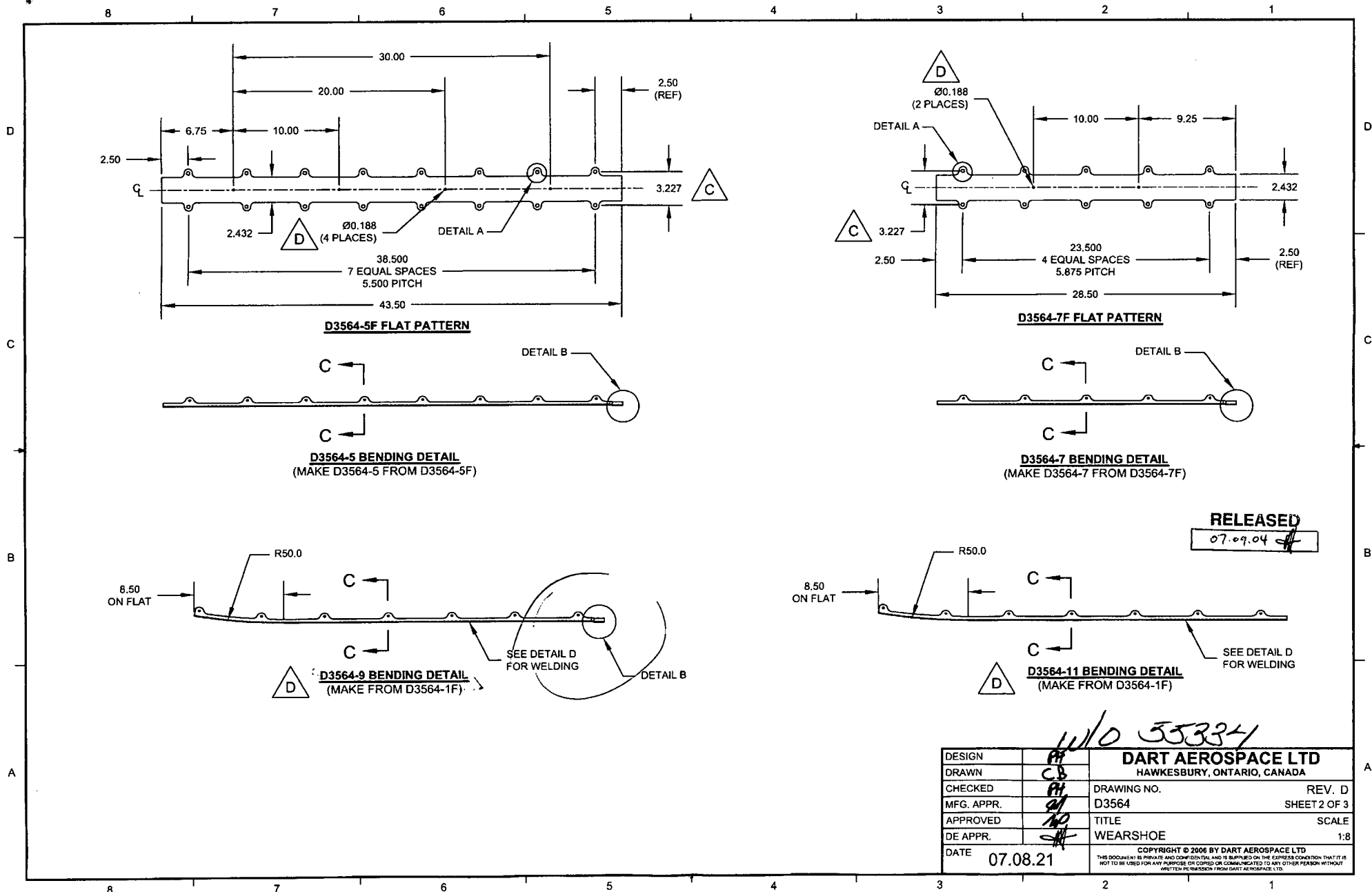
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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RELEASED  
07.09.04

1110 55334

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. D3564 TITLE WEARSHOE SCALE 1:8  <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
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CHECKED	PH	
MFG. APPR.	PH	
APPROVED	PH	
DE APPR.	PH	
DATE	07.08.21	

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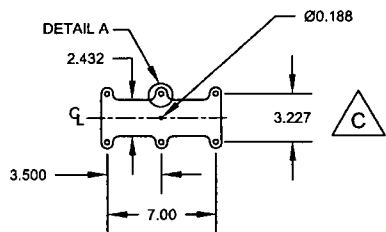
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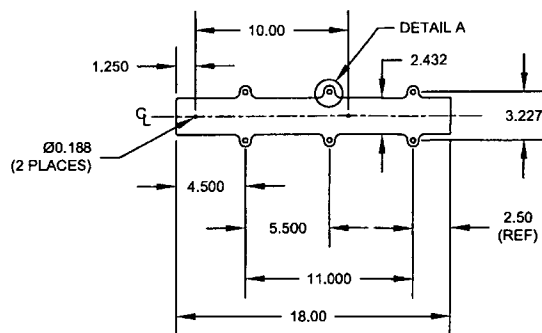
**NOTE:** Date & initial all entries



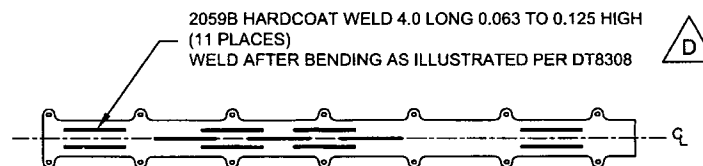
8 7 6 5 4 3 2 1



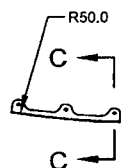
**D3564-13F FLAT PATTERN**



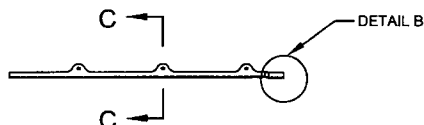
**D3564-15F FLAT PATTERN**



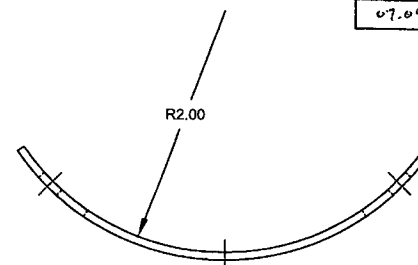
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



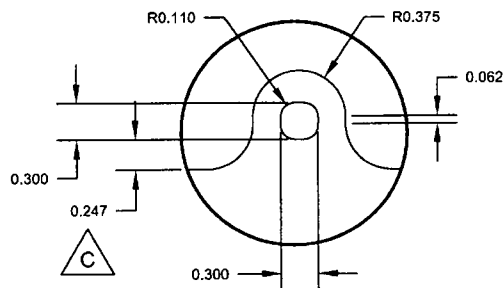
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



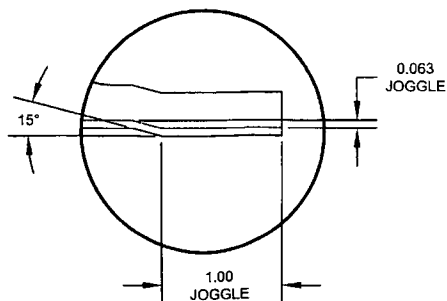
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

**RELEASED**

07.09.04

*W/0 55334*

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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